

Date: Tuesday, 8/21/2007 3:43:58 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEM
Job Number : 34196A
Estimate Number : 10399
P.O. Number : N/A Part Number : D29683
This Issue : 8/21/2007 S.O. No. : N/A Drawing Number : D2968
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B/C
Previous Run : 33362A Material : N/A
Written By : Due Date : 9/20/2007 Qty: 20 Um: Each
Checked & Approved By : 07.08.22
Comment : Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NR0750 4130 steel rod .750"



Comment: Qty.: 0.3762 f(s)/Unit Total : 7.5243 f(s)
Material: AISI 4130 Ø 3/4 " Bar
(M4130N-R0.750) Batch: 104452
Identify AS D2968-3

20 07/08/27

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-Turn Blank as per Folio FA048 and Dwg D2968
2-Deburr, no sharp edges

20 07/08/27 DSP 07/08/28 (21)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/08/27 DSP 07/08/28 (21)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA048 and Dwg D2968
2- Deburr

21 07/08/28 (21)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

21 07/08/28 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 34196A

Part Number: D29683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/10

(20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5755

7/9/11 50

(742)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/07/11

Job Completion



U 8-8-11

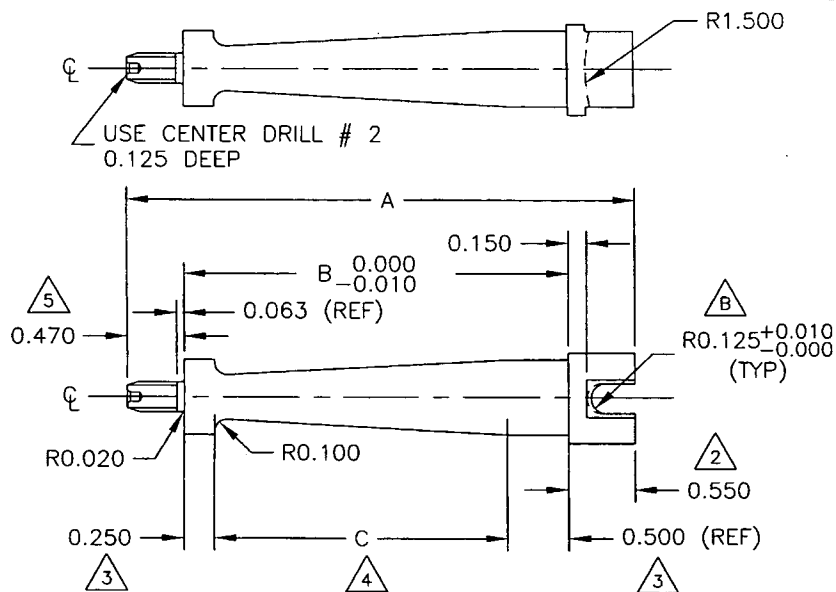
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

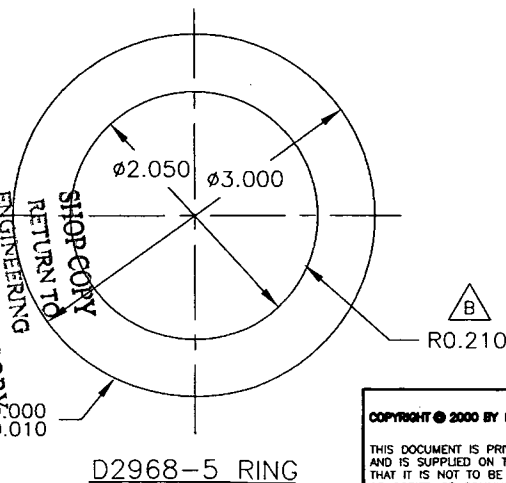
- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D.
TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 34196A
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO A REVISION
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

R0.125^{+0.000}_{-0.010}



D2968-5 RING

D2968-5 RING

1/8

USE D2968-1 STEM
FOR -041
USE D2968-3 STEM
FOR -043

RELEASED
07-04-18

D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	TITLE	SCALE 1:1
07.04.17	TOW RING	

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